

Change Request Details - CM/22-23/0386

Name of the Supplier	RANE BRAKE LINING LTD(100124)
Name of the Change Initiator	D.Christopher Jabaraj
Request Date	Nov 29, 2022
Proposal For	New Change
Proposed Changes	Change in process parameters /Process flow sequence
Process Route Change Details	
Description of Proposed Change	Current Process for Back plate Preparation Shot Blasting --- Adhesive coating (Individual process) -- Baking (Individual process) Proposed Process Wet Blasting -- Phosphating -- Online adhesive coating and Baking Benefits : 1) Fully automatic process from Wet blasting to Phosphating 2) Process controlled by Detection and Prevention Poka yoke 3) Online process enhances process robustness and reduces risk of part mix ups 4) Process Lead time is reduced

Part Details related with change

ETL Plant	Customer	Part No.
1159,1156,1141,1120,	BAL,YAMAHA,REML,	520BS00106,520BS00206,520BS01006,520BS01106,B2BS00130O,B2BS00230O,B2BS01330

Current Details (Before)	Back plate preparation process is shot blasting , Adhesive coating & baking
Trigger for the Change	Low Process Robustness Old Technology Man involvement is High
Proposed Details (After)	Fully automatic wet blasting , Phosphating , Online Adhesive coating and baking
Proposed Benefits of the Change	Quality Improvement, Productivity Improvement, Ease of Operations
Current Status	Inprocess
Status Updated By	302090
Status Update Date	Dec 5 2022 4:12PM

Implementation Plan

Activity	Target Date	Responsibility	Status

Reference Files

File For	File Name
Proposed Details (After)	View File

Activities For Final Approval

Activity	Answer	Responsibility	ETL Remarks	Supplier's Remarks	Final Remarks	Status	Plant	Department
Samples required	Yes	Supplier				Pending	1120	PlantQA

Assembly trial required	Yes	Supplier				Pending	1120	PlantQA
Testing and validation required	Yes	Supplier				Pending	1120	PlantQA
PPAP documents required	Yes	Supplier				Pending	1120	PlantQA
Customer approval required	Yes	ETL	Need to check for customer approval			Pending	1120	PlantQA
Samples required	Yes	Supplier				Pending	1156	PlantQA
Assembly trial required	Yes	ETL				Pending	1156	PlantQA
Testing and validation required	Yes	Supplier				Pending	1156	PlantQA
PPAP documents required	Yes	Supplier				Pending	1156	PlantQA

Approval Process History

Role	Employee	Request Status	Comments	Updated On	Status
PlantQA	854881 - Omprakash Sunkawar	Concept Approved	Conceptually approved subject to Samples validation at ETL,PPAP doc ,onsite Process audit	Dec 5 2022 2:54PM	1120
PlantQA	700254 - Dinesh De	Concept Approved	Conceptually Ok but need validation at ETL with PPAP doc.	Dec 5 2022 3:47PM	1156
SQA	302090 - Atul Khoche	Concept Approved	Conceptually Approved, subjected to PPAP approval and sample validation & approval as required by R & D AND Plant QA.	Dec 5 2022 4:12PM	
PlantQA	851720 - Pravin Kulkarni	Pending For Conceptual Approval			1141
PlantQA	851720 - Pravin Kulkarni	Pending For Conceptual Approval			1159
PlantQA	855352 - Ravi Nawkar	Pending For Conceptual Approval			1120
Sourcing	301640 - Shrikant Muley	Pending For Conceptual Approval			
Sourcing	856030 - Prasad Upadhye	Pending For Conceptual Approval			